

Date: Thursday, 2/8/2007 12:42:50 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LATCH BRACKET
Job Number : 30716	
Estimate Number : 10994	
P.O. Number : N/A	Part Number : D2583
This Issue : 2/8/2007 S.O. No. : N/A	Drawing Number : D2583 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : 28018	Material : N/A
	Due Date : 3/15/2007
Written By :	Qty: 100 Um: Each
Checked & Approved By : <u>07.02.08</u>	
Comment : Est: 00.11.01 Removed P/O for Powder Coat- in house processDM	
Est: D 06.07.21 Waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.1227 sf(s)/Unit Total : 12.2745 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick 9.9381

(M5052H32S040)

Batch: M102448

M102723 x18 2.2086

(100)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2583

Dwg Rev: B

Prog Rev: B

ml 07 03 13

(100)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr

Form on CNC Brake as per Dwg D2583


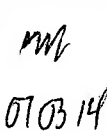

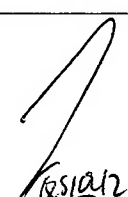
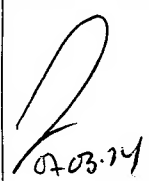
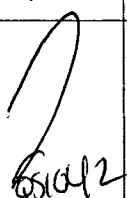


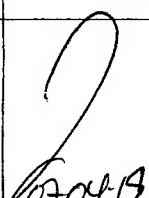
7
 07/04/18
 SB 07/04/19

1070
 97

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/14	2.0 3.0	1 part fell into the tube Tub.	 07/04/12	Qty 99 remain	 07/03/14	 07/03/14	 07/03/14	 07/03/14
07/04/18	5	2 piece scrap at the cabin	 07/04/12	Scrap + destroy		 07/04/18	 07/04/12	 07/04/18

NOTE: Date & initial all entries

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Drawing Name: LATCH BRACKET

Job Number: 30716

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-23
QSP019

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m.d *07/04/24* *(97X)*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MSA *07-04-25* *(97)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CP *07/04/26* *(97)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP *07/04/26* *(97)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/27 *(97)*

Job Completion



u *07-04-27*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

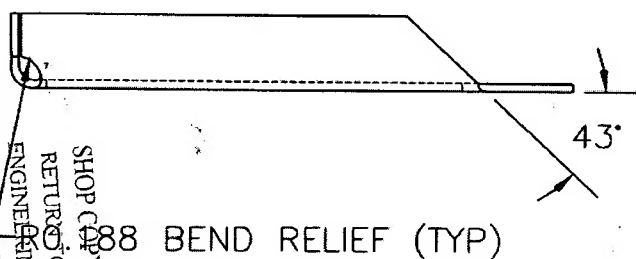
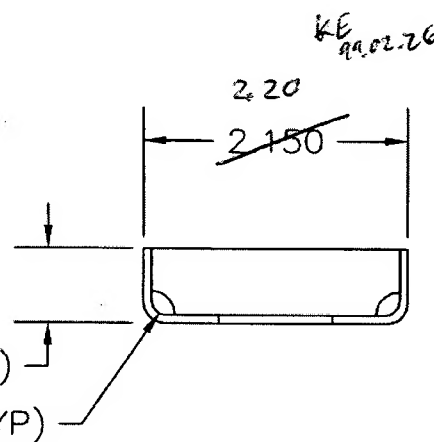
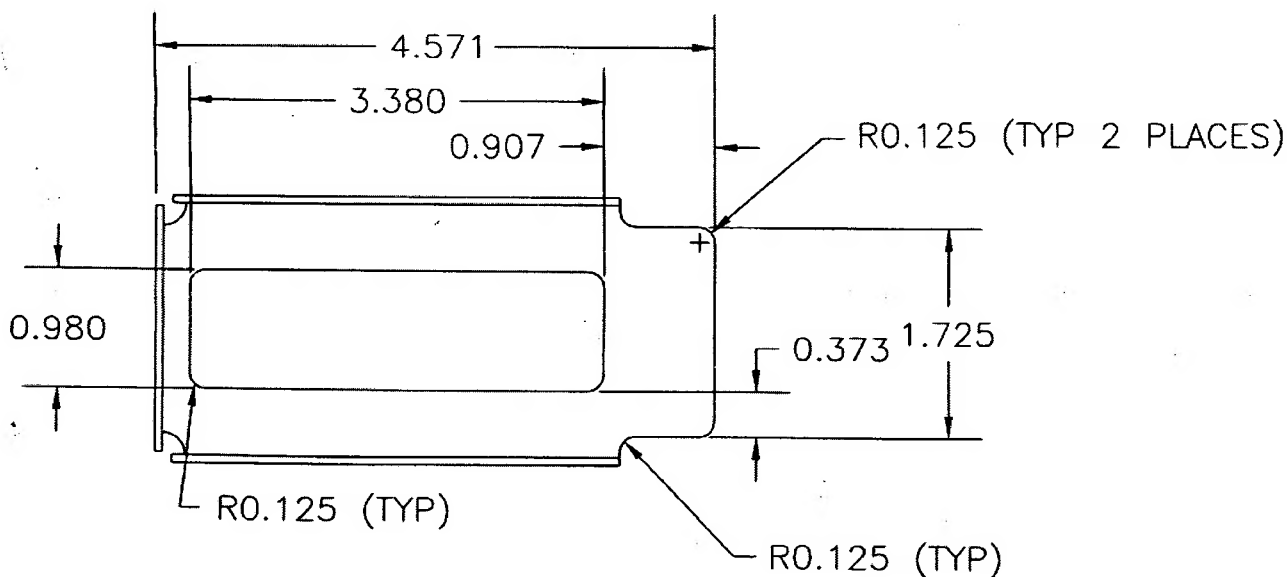
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QA COPY ISSUED

DESIGN MIKE M.		DRAWN BY RF		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. B	
CHECKED	APPROVED	DRAWING NO.		SHEET 1 OF 1			
99.02.22		D2583		TITLE		SCALE	
		LATCH BRACKET				2:3	
A	96.07.10	NEW ISSUE					
B	99.02.22	CHANGE OF FINISH (PER TSR A887)					

RELEASE
DATE 99.02.25



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SHOP COPY
RETURN TO
ENGINEERING
~~UNCONTROLLED COPY~~
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30716

